

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013313**Date Inspected:** 13-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Yu Dong Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10, Tower Strut Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SD1-STSA4-5-139M-1-2A/B, 4A/B

SD1-STSA4-5-143M-1-2A/B, 4A/B, 21A/B, 22A/B

WD1-STSA4-5-139M-1-2A/B, 4A/B

SD1-STSA4-5-119M-1-2A/B, 4A/B

WD1-STSA4-5-119M-1-2A/B, 4A/B

SD1-STSA4-5-123M-1-2A/B, 4A/B

WD1-STSA4-5-123M-1-2A/B, 4A/B

SD1-STSA4-5-127M-1-2A/B, 4A/B

WD1-STSA4-5-143M-1-21A/B, 22A/B

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This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 11

WEST TOWER LIFT 5, AE CORNER REPAIR (T-WR3160, REV. 0, Y=0)

SMAW welding of weld joint 12A/B (Repair) located on WSD1-TL5-4B/F.

Welder is identified as 044541. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR-1.

TOWER GRILLAGE PLATE

SAW welding of weld joint 10A located on GTSA5-B/G.

Welder is identified as 047304. ZPMC QC is identified as Mr. Shao Hui Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 19A located on GTSA5-B/G.

Welder is identified as 042195. ZPMC QC is identified as Mr. Shao Hui Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

TOWER STRUT ANGLE CONNECTION PLATE

SMAW welding of weld joint 1A located on WD1-SA4-56-127M-1.

Welder is identified as 046704. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

SMAW welding of weld joint 1A located on ND1-SA4-69-119M-1.

Welder is identified as 040667. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

TOWER SKIRT PLATE

FCAW welding of weld joint 3 located on ESD1-A65B/B.

Welder is identified as 042218. ZPMC QC is identified as Mr. Xu Jin Long.

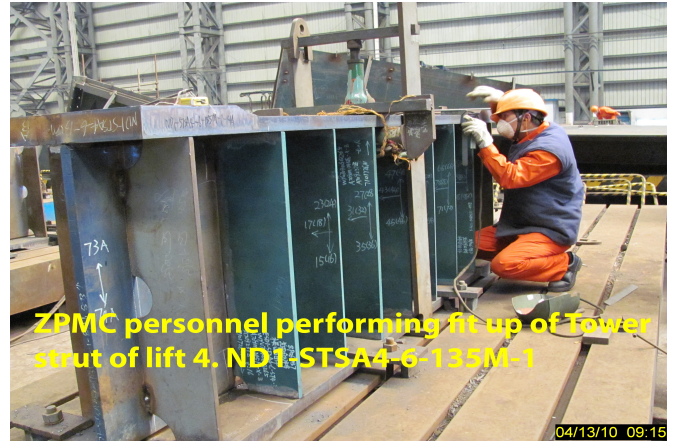
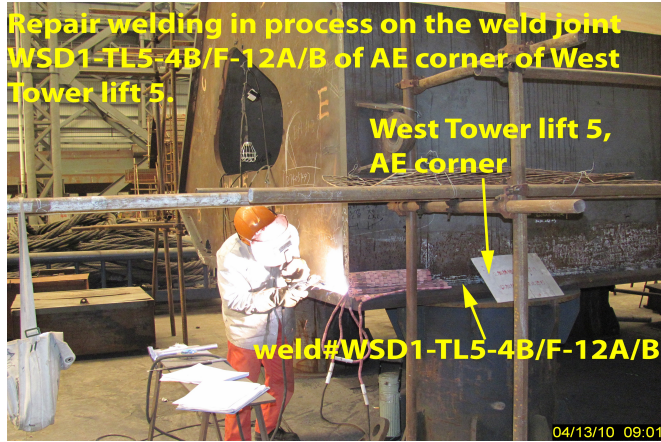
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

During random in process inspection, this QA inspector observed that ZPMC personnel were performing fit up of ND1-STSA4-6-135M-1 of Tower lift 4, strut plate. Attached photographs provide additional details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer